

CLAIMS

The embodiments of the invention in which an exclusive property or privilege is claimed are defined as follows:

1. An article of footwear comprising:

an upper including a lower portion;

a midsole extending along a length between a forward most portion and a rearward most portion, said midsole including opposing sidewalls that extend from said rearward most portion to said forward most portion and form a visible exterior of said midsole, said midsole including an upper surface and a bottom surface, said upper surface direct attached to said lower portion of said upper, said bottom surface including at least one midsole bottom surface trim line positioned inward a preselected distance from said side wall on said bottom surface, said midsole bottom surface trim line non-coincident with said side wall; and

an outsole joined with said bottom surface of said midsole and concealing said midsole bottom surface trim line.

2. The article of footwear of claim 1 wherein said outsole is substantially flat.

3. The article of footwear of claim 1 wherein the midsole bottom surface includes a periphery corresponding to the shape of a wearer's foot.

4. The article of footwear of claim 3 wherein the outsole terminates with the midsole bottom surface so that the side wall is substantially uncovered by the outsole.

5. The article of footwear of claim 1 wherein the upper includes an insole, said insole joined with the lower portion of the upper to close the upper.

6. The article of footwear of claim 1 wherein the lower portion includes a peripheral edge bent inward toward the center of the shoe.

7. The article of footwear of claim 1 wherein the midsole includes a side wall trim line in substantially only at least one of the forward most portion and the rearward most portion of the midsole.

8. The article of footwear of claim 7 wherein the side wall trim line is substantially only vertical.

9. The article of footwear of claim 1 wherein the midsole is formed with opposing side molds abutted against a lower mold along a seam, wherein the midsole bottom surface trim corresponds to the seam.

10. A footwear construction comprising:

an upper;

a midsole including a lateral side wall, a medial side wall, an upper surface direct attached to said upper, and a bottom surface, said bottom surface bounded along a medial edge by said medial side wall and a lateral edge by said lateral side wall, said medial side wall and said lateral side wall extending upwardly from said bottom surface to said upper, said midsole including a bottom surface trim line positioned inward from said lateral side wall and said medial side wall; and

an outsole joined with said midsole bottom surface that conceals substantially all of said bottom surface trim line.

11. The footwear construction of claim 10 wherein said outsole is substantially flat and extends substantially only across said width.

12. The footwear construction of claim 10 wherein said midsole bottom surface trim line corresponds to the shape of a wearer's foot.

13. The footwear construction of claim 12 wherein said lateral side wall and medial side wall terminate in at least one of a forward portion and a rearward portion of the midsole, and wherein a side wall trim line is positioned in substantially only at least one of said forward portion and rearward portion.

5 14. The footwear construction of claim 10 wherein the upper includes a lower portion and an insole is secured to the lower portion, wherein the midsole is direct attached to the insole.

15. The footwear construction of claim 10 wherein said midsole includes a first vertical side wall trim line at a forward most portion of the midsole and a second vertical side wall trim line at a rearward most portion of the midsole.

10 16. A method for manufacturing an article of footwear comprising:

providing an upper;

closing a plurality of side molds against a lower mold to define a midsole cavity, the side molds including a first surface corresponding to at least one side wall of a midsole, the lower mold including a second surface corresponding to at least a portion of a bottom surface of the midsole, the lower mold and side molds further defining a seam therebetween;

15 introducing material into the midsole cavity to form the midsole including the at least one side wall and the bottom surface, the material seeping into the seam to form a flashing disposed substantially only on the bottom surface of the midsole;

removing the midsole from the mold; and

20 securing an outsole to the midsole.

17. The process of claim 16 comprising removing the flashing to form trim lines before attaching the outsole to the midsole.

18. The process of claim 16 comprising securing the outsole substantially only to the bottom surface of the midsole.

19. The process of claim 16 wherein the upper includes a lower portion and is enclosed with an insole joined with the lower portion.

5 20. The process of claim 16 wherein said trim line is positioned inward from said side walls of the midsole a preselected distance.